

Date: Tuesday, 3/6/2007 8:55:57 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CUFF
 Job Number : 31024
 Estimate Number : 12774
 P.O. Number : N/A Part Number : D36061
 This Issue : 3/6/2007 S.O. No. : N/A Drawing Number : D3606 Rev. A Prelim Issue 07.03.05
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : UNDER REVIEW
 Previous Run : Material : N/A
 Written By : Due Date : 3/13/2007 Qty: 2 Um: Each
 Checked & Approved By :
 Comment : est rev A new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R3500 Inventory



Comment: Qty.: 0.5250 f(s)/Unit Total : 0.5250 f(s)
 6061-t6 round bar 3.500" dia.
 batch: M100720

07.03.05

(2)

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per folio N/A & DWG D3606,
 FOLIO REV: N/A
 DWG REV:

07.03.05

(2)

2-Deburr as required

07.03.05

(2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.03.05

(2)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07.03.05

(2)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

N/A OK 07.03.06

for test only.

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User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUFF

Job Number: 31024

Part Number: D36061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



07.03.05 (2)

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

~~Identify and Stock~~

Location: _____

Used for testing. Engineering use only.
BK 07.03.06

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/06

Job Completion



PRELIMINARY ISSUE

07.03.02

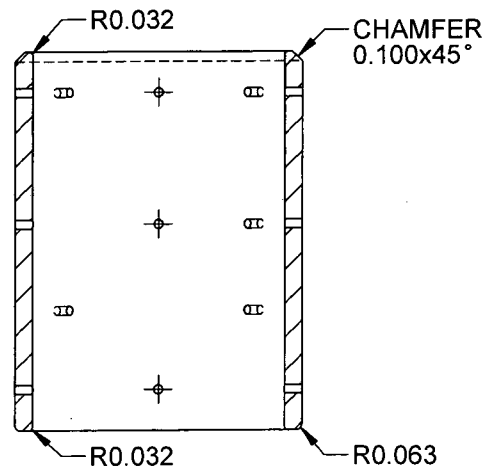
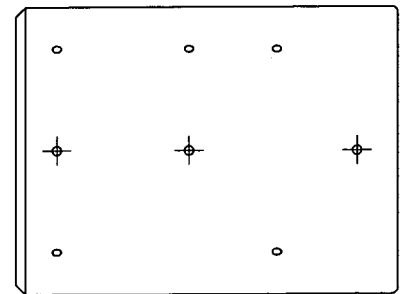
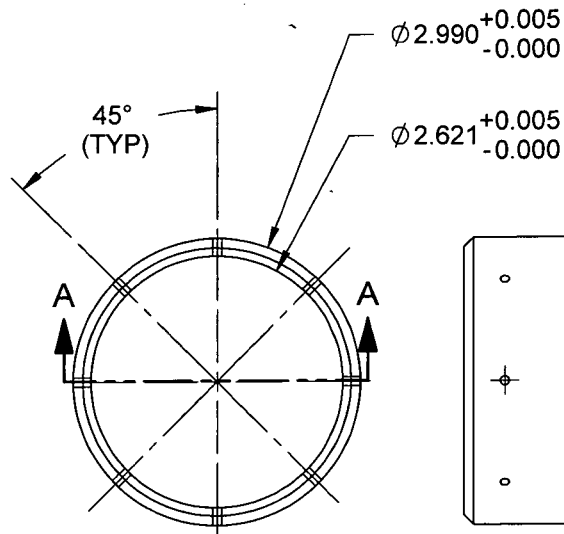
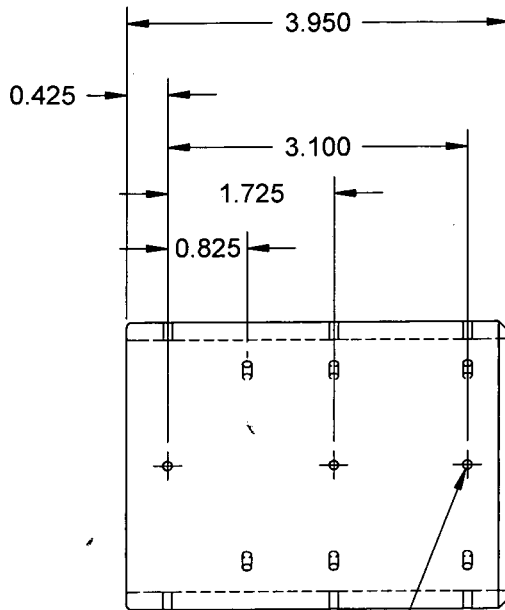
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3606	REV. A SHEET 1 OF 1
DATE 07.03.01	TITLE CUFF		SCALE 1:2
A	07.03.01	NEW ISSUE	

Qty (2)

Job 00085

M100720

M6061T6R3500
12"



SECTION A-A

D3606-1 CUFF

NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAR QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED


PROTOTYPE REQUEST FORM

Part Number	Drawing Number Date	Qty.	Material Cert Required (Y/N)	Due Date	Comments
D3606	D3603 07.03.01	2	Y	ASAP	X-TUBE 4126F
	D3606 Prelim. 07.03.02				q1 07.03.02

07.03.05 (2)

Job/Project Number: 00085

Design Engineer/Project Manager Name/Signature/Date:

Design Manager Signature/Date:  1 MAR 2007

Date: Thursday, 05/04/2007 8:22:47 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D350607/D130-701
Job Number	: 31646		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 05/04/2007 S.O. No. : N/A	Drawing Number	: UPDATE PAPERWORK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : OVERHEAD	Drawing Revision	: N/A
Previous Run	: 31555	Material	: N/A
Written By	: _____	Due Date	: 12/04/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	: _____		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

D350-607-041 B 142 B31575

D350-607-043 B

D350-607-045 B B28896 CH1D350-607-047 B B30859 CH1

D130-701-041

ADD NEW PAPERWORK DSI 9370
 AND RETURN TO STK

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 2.04.10



935, boul. du Havre

Valleyfield (Québec)

J6S 5L1

TÉLÉPHONE : (450) 377-4248

FAX : (450) 377-5696

ONTARIO : 1-800-667-4248

MONTRÉAL : (514) 336-4248

FAX : (514) 336-4246

DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS

STEEL AND SPECIALTY METALS DISTRIBUTOR

On a du Savoir "FER"

VENDU À / SOLD TO:

613-632-3336

613-632-4443

EXPÉDIEZ À / SHIP TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

RECEIVED APR 27 2006

FACTURE
INVOICE

N° 159476

DATE

20/04/06

BON DE LIVRAISON
PACKING SLIP

N° 108356

DATE DE LIVRAISON
DELIVERY DATE

20/04/06

OTRE N° DE COMMANDE / YOUR P.O. N°	VEND. / SALESM.	CODE CLIENT / CUST. CODE	EXPÉDIE PAR / SHIP VIA	TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
981	D	DAER		NET 30 JOURS	SR		001

NOMBRE QUANTITY	CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIE SHIPPED	DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
		1	1	ALUM. HEX 1" 1 X 12' 6061-T6	1	60.000		60.00
		1	1	ALUM. ROUND BAR 3.5"DIA 1 X 12'	1	439.990		439.99
				ENERGICAL SURCHARGE				

Unités de mesure : CLB Cent livres • CPI Cent pieds • UN Unité • PI Pied • PC Pied carré
Units of measure: Hundred pounds Hundred feet Unit Foot Square foot

POIDS TOTAL 2.00
TOTAL WEIGHT

CONDITIONS:
LES MATÉRIAUX LIVRÉS ET FACTURES TELS QU'ÉCRITS DEMEURENT LA PROPRIÉTÉ DE "ACIER CAMP I INC." JUSQU'À PARFAIT PAIEMENT COMPLET
NCAISSÉ. • LES RISQUES DE PERTES OU BIEN SONT À LA CHARGE DE L'ACHETEUR. • LA GARANTIE DE QUALITÉ DU MATÉRIEL EST LA MÊME QUE
ELLE DU FABRIQUANT. • L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES : NET 30 JOURS DE LA DATE DE FACTURATION. ET
OUT COMPTE IMPAYÉ DANS LES 30 JOURS ENTRAÎNE DES FRAIS DE 2% PAR MOIS (24% PAR ANNÉE) QU'IL ACCEPTE DE PAYER. • TOUT DÉFAUT
REÇU EN L'UNE OU L'AUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCHÉANCE DU TERME ET PERMET AU VENDEUR
SON CHOIX, D'ALLÉGER TOUT SOLDE DU PRIX DE VENTE OU REPRISE LE BIEN VENDU. • TOUTE RÉCLAMATION DOIT ÊTRE FAITE DANS LES
UN JOUR SUR PRÉSENTATION DE CE DOCUMENT. • TOUTE MARCHANDISE ENDOMMAGÉE, ALTÉRÉE OU COUPÉE NE PEUT ÊTRE REPRISE. • AU
UN RETOUR DE MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. • TOUTE MARCHANDISE RETOURNÉE EST SUJETTE À DES FRAIS
DE MANUTENTION DE 25%.

CONDITIONS:

ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ACIER CAMP I INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
ALL LOST MATERIALS ARE AT THE BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. • THE BUYER
HEREBY ACCEPTS TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY ADMINISTRATIVE
CHARGES OF 2% PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH THIS
CONTRACT WILL LEAD TO PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE REPOS-
SESSION OF THE GOODS SOLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE THAT
HAS BEEN DAMAGED, CUT OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SUB-
JECT TO A 25% RESTOCKING CHARGE.

MARCHANDISE REÇUE EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

PRÉPARÉ / PREPARED	VÉRIFIÉ / VERIFIED	LIVRÉ / DELIVERED	HEURE / TIME
PAR BY		PAR BY	

X

A/Y M/M J/D

DATE

SOUS-TOTAL 499.99
SUB TOTALT.P.S. 35.00
G.S.T.T.V.Q. 0.00
G.S.T.

TOTAL 534.99

**KAISER ALUMINUM
MATERIAL CERTIFICATION**

KAISER ALUMINUM
ENGINEERED PRODUCTS
9700 SOUTH HARLEM AVE
BRIDGEVIEW IL 60455

PAGE 1

<u>PQ H7S-1 C58623</u>		<u>01/27/06</u>
<u>SOLD TO</u>	<u>PURCHASE ORDER</u>	<u>DATE PRINTED</u>
<u>512/STK</u>	<u>3.500 IN ROD +/- .012 TOL</u>	
<u>CUSTOMER PART NUMBER</u>	<u>DESCRIPTION</u>	
<u>1815201</u>	<u>978351-002</u>	<u>73941 255</u>
	<u>RELEASE-ITEM</u>	<u>LOT</u>
		<u>6061-T6511</u>
		<u>ALLOY/TEMPER</u>

B/L 929 569

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	%Elong in 2"	HARDNESS	CONDUCT.	BEND
XTR040864	0001 01	51.5	47.8	11.4		N/A	N/A
XTR040864	0004 01	54.9	50.3	11.6		N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Others
6061 LIMITS												
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	0.05 0.15
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA	

APPLICABLE REQUIREMENTS:

ASTM-B221-02-STENCILED
ASME-SB221 1998 SECT II
AMS-QQ-A-200/8
UNS#96061

Kaiser Aluminum & Chemical Corp. ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

02/01/06

Frank E. Watson
Quality Assurance Manager